

Work Order ID 133224

Wednesday, May 27, 2015 12:53:40 PM

133224

Page 1

Item ID: DSI 9724-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Shim Installation

Stop

NS2

Start Date: 5/28/15 Start Qty: 3.00

3

Cust Item ID:

Required Date: 5/29/15 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date: 5.5.27

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9724	A

100

Document Control

0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPP DSI9724-011 CHG001

MAY 28 2015

MAY 29 2015

3

DAS
6
9-89

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

MAY 28 2015

NO

DAS
26
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

MAY 29 2015

3

DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work Order ID 133224

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133224

Page 2

Item ID: DSI 9724-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Shim Installation

Stop ***NS2***Start Date: 5/28/15 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 5/29/15 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D9052-011								
	Location: <u>Ship</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MAY 29 2015

DAS
6
9-89

MAY 29 2015

MAY 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Wednesday, May 27, 2015 12:53:47 PM

Page 1

Work Order ID: 133224

133224

Parent Item: DSI 9724-011

DSI 9724-011

Parent Item Name: Shim Installation

Start Date: 5/28/15

Required Date: 5/29/15

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 15.05.27 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A		Purchased	No				Each	487.0000		12			
---------	--	-----------	----	--	--	--	------	----------	--	----	--	--	--

AN4-13A

Bolt

DAS
6
9-89

Location

Loc Qty

Loc Code

FG	20	
122808	20	
ST325A	443	
m131957	200	
m132317	243	
ST344	24	
131677	24	

D5253-1

Manufactured No

D5253-1

Shim

**

12

DAS
26
9-89

DAS
6
9-89

B133224 x 12

MAY 28 2015

DAS
26
9-89

MAY 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 2

Work Order ID: 133224

133224

Parent Item: DSI 9724-011

DSI 9724-011

Parent Item Name: Shim Installation

Start Date: 5/28/15

Required Date: 5/29/15

Start Qty: 3.00

Required Qty: 3.00

MS21042L4

Purchased

No

Each

5,571.000

12

MS21042L4

Locknut

**

DAS
26
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

26

m124231

26

GA

216

m127813

216

ST260a

4062

m130799

56

m131803

6

m132262

1000

m132382

3000

ST305

1267

m128300

8

m130388

7

m130922

97

m131618

12

m132123

1143

NAS1149D0416J

Purchased

No

Each

4,882.000

24

NAS1149D0416J

WASHER

**

MAY 28 2015

DAS
26
9-89

Location

Loc Qty

Loc Code

ST270

4882

m131511

4882

DAS
6
9-89

24

MAY 28 2015

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D117-837 REV. B AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D117-837 REV. 1
REF. TCCA STC: SH13-22
REF. FAA STC: SR03353NY

1.0 Purpose

Some customers have experienced problems with the alignment of the quick release pins after installing the D117-837-011 Basket kit after CHG 003. The purpose of this DSI is to provide instructions and parts to correct this mis-alignment. The DSI 9724-011 Shim Kit provides tapered shims that may be installed between the D5106-041 Bracket Assemblies and the bottom rib of the D4784-041 Basket Assembly.

2.0 Installing D5253-1 Shims

- 2.1 Unfasten D5106-041 Bracket Assy from D4784-041 Basket Assy.
- 2.2 Replace AN4-12A bolts with AN4-13A bolts and install D5253-1 shims as shown in Figure 1, using 2x NAS1149D0416J washers and 1 x MS21042L4 nut per shim. Pay attention to the orientation of the shim in relation with the basket center. Position the 4x D5253-1 Shims with the thicker side away from the center of the basket.
- 2.3 Fasten D5106-041 Bracket Assy to D4784-041 Basket Assy.
- 2.4 Continue with step 3.1.3 of IIN-D117-837 Rev. B.

3.0 Parts List

For D117-837-011 Heli-Utility-Baskets @ CHG 003 and later, the DSI 9724-011 Shim Kit is available from Dart. The parts in the DSI 9724-011 Shim Kit have been added to D117-837-011 Basket Kits @ CHG 006 and later.

Qty -011	Part Number	Description
X	DSI 9724-011	SHIM KIT
4	D5253-1	SHIM
4	AN4-13A	BOLT
4	MS21042L4	NUT
8	NAS1149D0416J	WASHER

4.0 Weight & Balance

This DSI has a negligible effect on Weight & Balance

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 15.05.11
CERT. NO.: SH13-22
ISSUE NO.: 1

A	NEW ISSUE	RF	15.05.11
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9724	SHEET 1 OF 2
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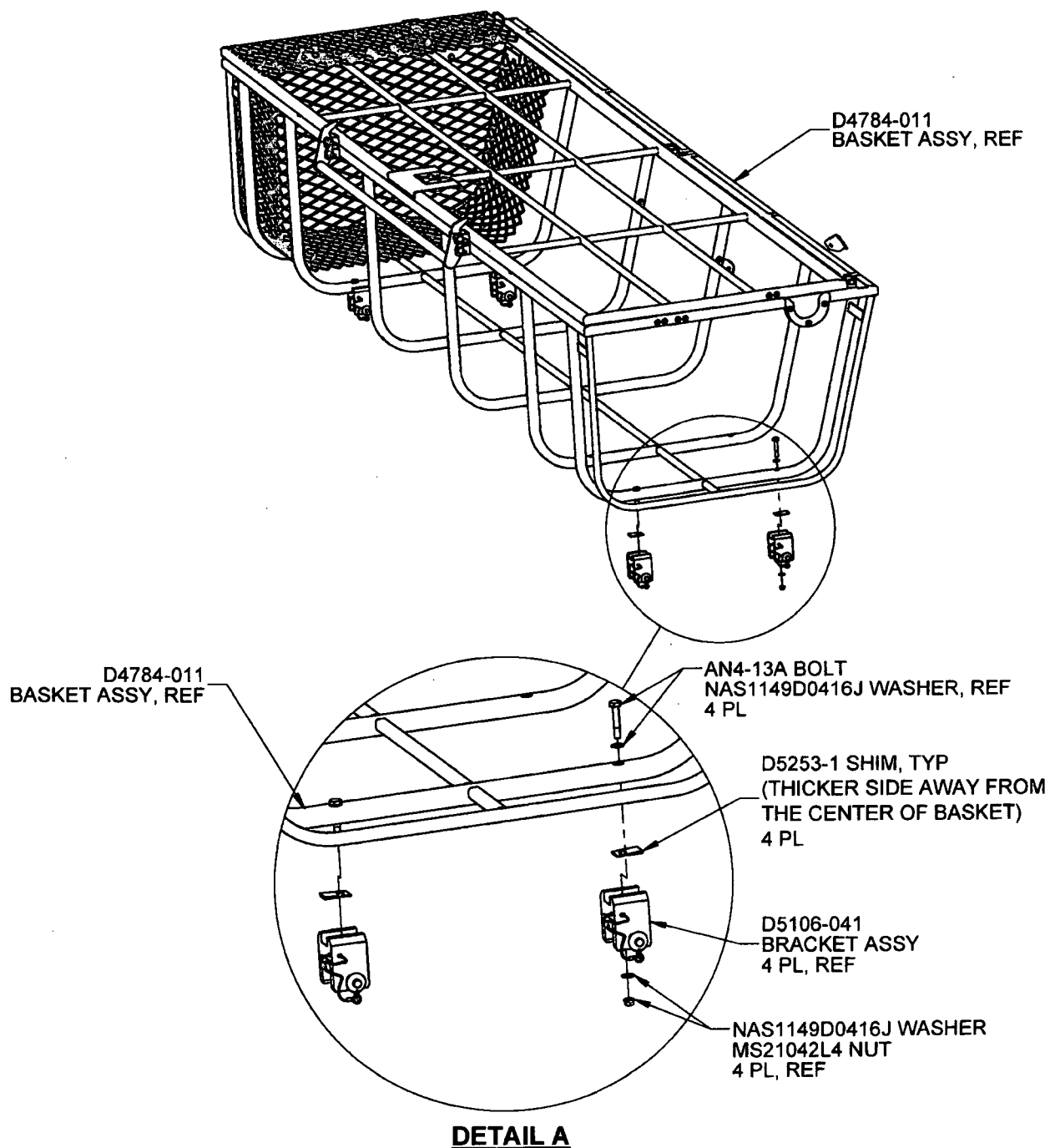


FIGURE 1 - D5253-1 SHIM INSTALLATION

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